



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.7710

Job Sheet 190737



Part No: 647.7710

Job Qty: 20 pcs

Part Name: Strut Tube



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/14/19

Job Tracking No:

Due Date: 3/22/19

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: DWG REV A2 IPP REV:A 12.11.06 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Conventional Mill - 1	20 pcs	3/22/19	3/22/19	0.00	3.60	Conventional Mill - 1		Fred 19-03-07
							Conventional Mill - 2		
120	QC 2	20 pcs	3/22/19	3/22/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		

19/3/7



Container No: S160423



Part: 647.7710

Job No: 190737

Serial No/Batch: S160423

Revision:

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/07/19

Plex 2/14/19 7:41 AM Dart.lajeunesse.marie

125 QC 8	20 pcs	3/22/19	0.00 0.00	QC 2 - 66	
				QC 2 - 64	
				QC 8 - 12	
				QC 8 - 14	20/19/03/13
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				130 Packaging 3-1 - Stock - B4B 20 pcs	
Packaging 3 - 2 - B4B					
Packaging 3 - 3 - B4B					
Packaging 3 - 4 - B4B					
Packaging 3 - 5 - B4B					
Packaging 3 - 6 - B4B					
Packaging 3 - 7 - B4B					
Packaging 3 - 8 - B4B					
Packaging 3 - 9 - B4B					
Packaging 3 - 10 - B4B					
Packaging 3 - 11 - B4B					
Packaging 3 - 12 - B4B	12				
Packaging 3 - 13 - B4B					
Packaging 3 - 14 - B4B					
Packaging 3 - 15 - B4B					
Packaging 3 - 16 - B4B					
Packaging 3 - 17 - B4B					
Packaging 3 - 18 - B4B					
Packaging 3 - 19 - B4B					
Packaging 3 - 20 - B4B					
Packaging 3 - 21 - B4B					
Packaging 3 - 22 - B4B					
Packaging 3 - 23 - B4B					
Packaging 3 - 24 - B4B					
Packaging 3 - 25 - B4B					
Packaging 3 - 26 - B4B					
Packaging 3 - 27 - B4B					
Packaging 3 - 28 - B4B					
Packaging 3 - 29 - B4B					
Packaging 3 - 30 - B4B					
Packaging 3 - 31 - B4B					
Packaging 3 - 32 - B4B					
Packaging 3 - 33 - B4B					
Packaging 3 - 34 - B4B					
Packaging 3 - 35 - B4B					
Packaging 3 - 36 - B4B					
					Plex 2/14/19 7:41 AM Dart.lajeunesse.mari

m/19/03/13

12



140 QC 21 - SA	20 pcs	3/22/19	0.00 0.00	QC 21 - SA - 21	MAR 13 2019	DAS
				QC 21 - SA - 70		70
				QC 21 - SA - 53		9-89

Part Op 110 - (Manufacture as per dwg) 1- CUT AS PER DWG 2- Mill end of tube as per dwg 3- DEBURR AS PER DWG
 Descriptions: 120 - (QC2- Inspect parts off machine FAI/FAIB)
 125 - (QC8- Inspect parts - second check)
 130 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M4130NT0.500W.083	4130 Round Tube .500 X .083W	16.4000 ft (.82 ea)	110-Conventional Mill - 1	S130961	

Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
110-Conventional Mill - 1	M4130NT0.500W.083	16	74	0	

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Strut Tube	9.750inches ± 0.005	9.755 9.745		
2	Strut Tube	0.500inches ± 0.005	0.505 0.495	Diameter	
3	Strut Tube	0.334inches ± 0.005	0.339 0.329	Diameter	
4	Strut Tube	0.188inches ± 0.005	0.193 0.183	Radius	

Plex 2/14/19 7:41 AM Dart.lajeunesse.marie

93/4

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS			
		Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐
Date :	Sequence #:	QTY Affected :			MRB (QSI042)
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor
					QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY			
		☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled	☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up	☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread
		Other/Details:			

